

# Work Order ID 56889

March 12, 2010 10:12:02 AM

Page 1

Item ID: D3694-041

Accept

Setup Start

Revision ID:

Stop

Item Name: MOUNTING PLATE

Start Date: 3/12/10 Start Qty: 4.00

Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan:

Date: 10-3-12 Tooling:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3694

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Install helicoils as per Dwg D3694 2-Install Protective & Mounting plate as per Dwg D3694

⇒ m. 10/03/18

(4x)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.06/18

(x4)

120

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

255

10-3-18 (4x) 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56889**

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Page 2

Item ID: D3694-041

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Required Date: 3/19/10 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10603/24 HJ

C21013119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

March 12, 2010 10:11:59 AM

Page 1

Work Order ID: 56889

Parent Item: D3694-041

Parent Item Name: MOUNTING PLATE

Start Date: 3/12/10

Required Date: 3/19/10

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM  
IPP Rev:B 09-01-13 As per Rev C JLM Verified By:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R8		Purchased	No				Each	613.0000	4.0000			



Screw

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST328

613

9216

613

Each

0.0000

20.0000

AN960JD10

Purchased

No



NAS114900363J

M113288

Washer

D3694-1

Manufactured

No



Each

1.0000

4.0000

Mounting Plate

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST255

1

55282

1

Each

4.0000

4.0000

D3694-3

Manufactured

No



MOUNTING PLATE ASSY

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST355

4

55492

4

4X m-k 10/03/18  
20X m-k 10/03/18 \*

4X m-k 10/03/18

4X m-k 10/03/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Work Order ID: 56889



Parent Item: D3694-041



Parent Item Name: MOUNTING PLATE

Start Date: 3/12/10

Required Date: 3/19/10

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM  
IPP Rev:B 09-01-13 As per Rev C JLM Verified By:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3694-5		Manufactured	No				Each	4.0000	4.0000			
MOUNTING PLATE ASSY												

MS21042L3



Nut

Purchased

No

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST255

53608

4

4

Each

2,289.000

16.0000



1X m-h  
3X 10/03/18

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST300

2289

110844

35

111274

27

111668

58

112314

285

112385

164

113523

20

113537

700

113644

1000

m-h  
16X 10/03/18

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D3694-041



Parent Item Name: MOUNTING PLATE



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Required Date: 3/19/10

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Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21209-F120		Purchased	No				Each	84.0000	8.0000			
												
HELI COIL												

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST304

84

107823

18

114037

66

MS24693-C271

Purchased

No

Each

5,472.000 4.0000



Screw

8X m-l 10/03/18

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST310

5472

1112

3825

1139

1180

1445

266

1664

201

4X m-l 10/03/18

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 3/19/10

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IPP Rev:B 09-01-13 As per Rev C JLM Verified By:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24693-C273		Purchased	No				Each	83.0000	16.0000			



Screw

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST310

83

107394

1

109962

13

111072 ✓

69

\_\_\_\_\_ m-l  
\_\_\_\_\_ 10/03/18  
~~16X~~

March 12, 2010 10:12:00 AM

Shop Packet Print

Page 4

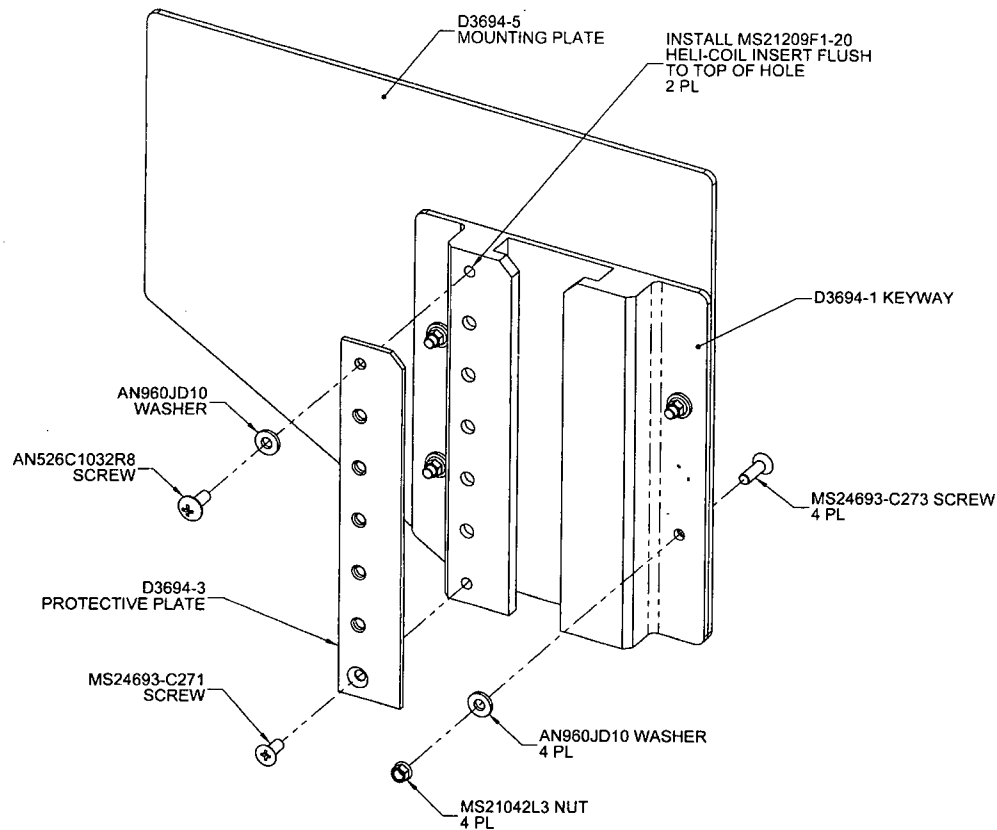
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3694-041 MOUNTING PLATE ASSY**

**D3694-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54889

*PHIO-3-16*

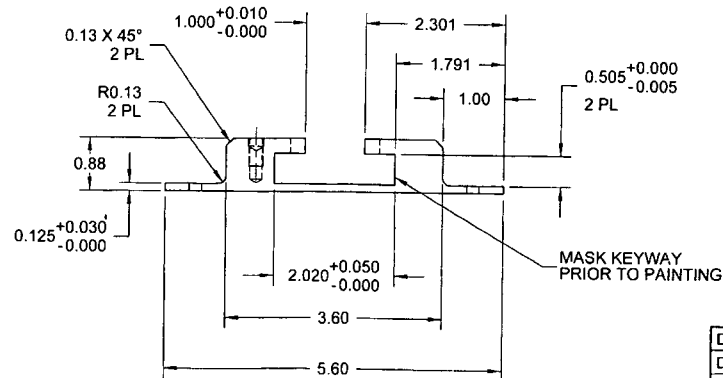
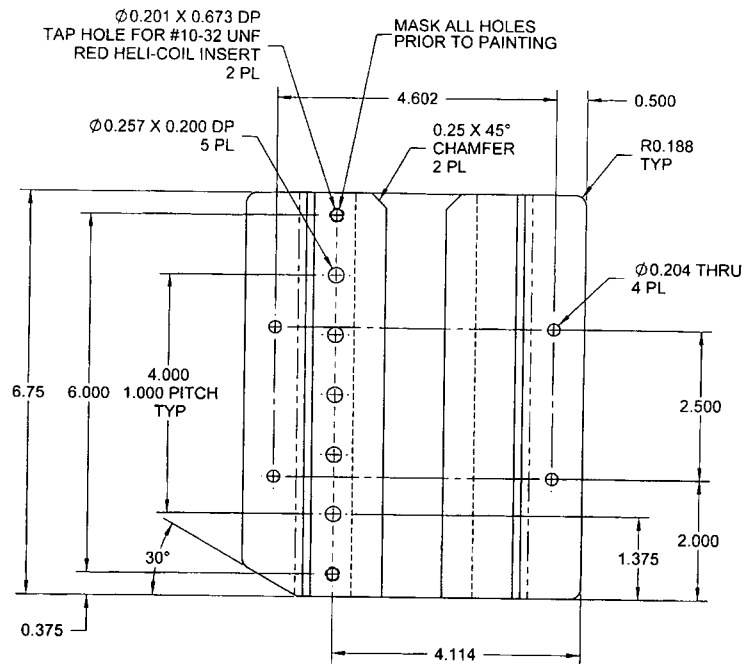
**RELEASED**  
*01/12/05 MB*

C	REDESIGNED ITEM 11; REVISED ITEM 12: DIM Ø0.204 WAS Ø0.234 (ZN D3-3); ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1); REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY: 1 MS24693-C271 SCREW WAS QTY. 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3); REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.08.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3694** REV. C  
SHEET 1 OF 4  
TITLE **MOUNTING PLATE ASSY** SCALE NTS

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**D3694-1 KEYWAY**

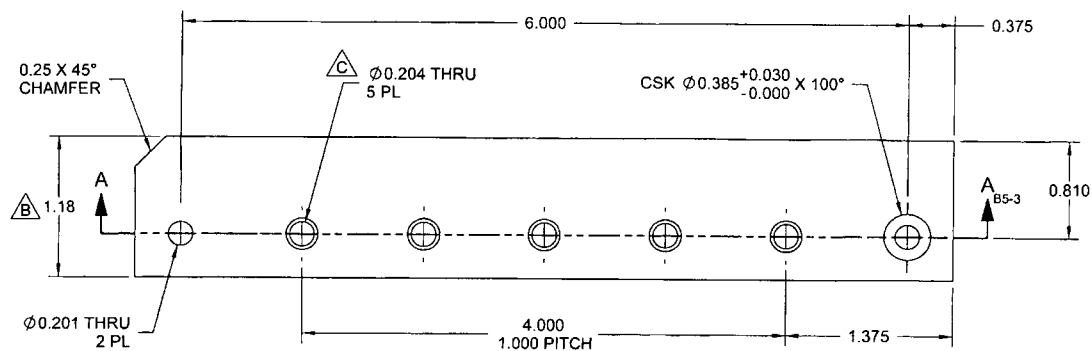
**D3694-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART  
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

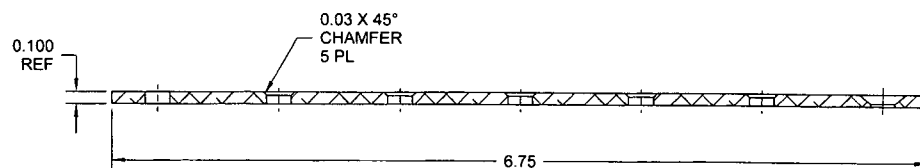
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3694</b>	REV. C
MFG. APPR.		TITLE	SHEET 2 OF 4
APPROVED		<b>MOUNTING PLATE ASSY</b>	SCALE
DE APPR.			NTS
DATE	<b>08.11.03</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
09/04/05

w/o 56889



**D3694-3 PROTECTIVE PLATE**



**SECTION A-A**

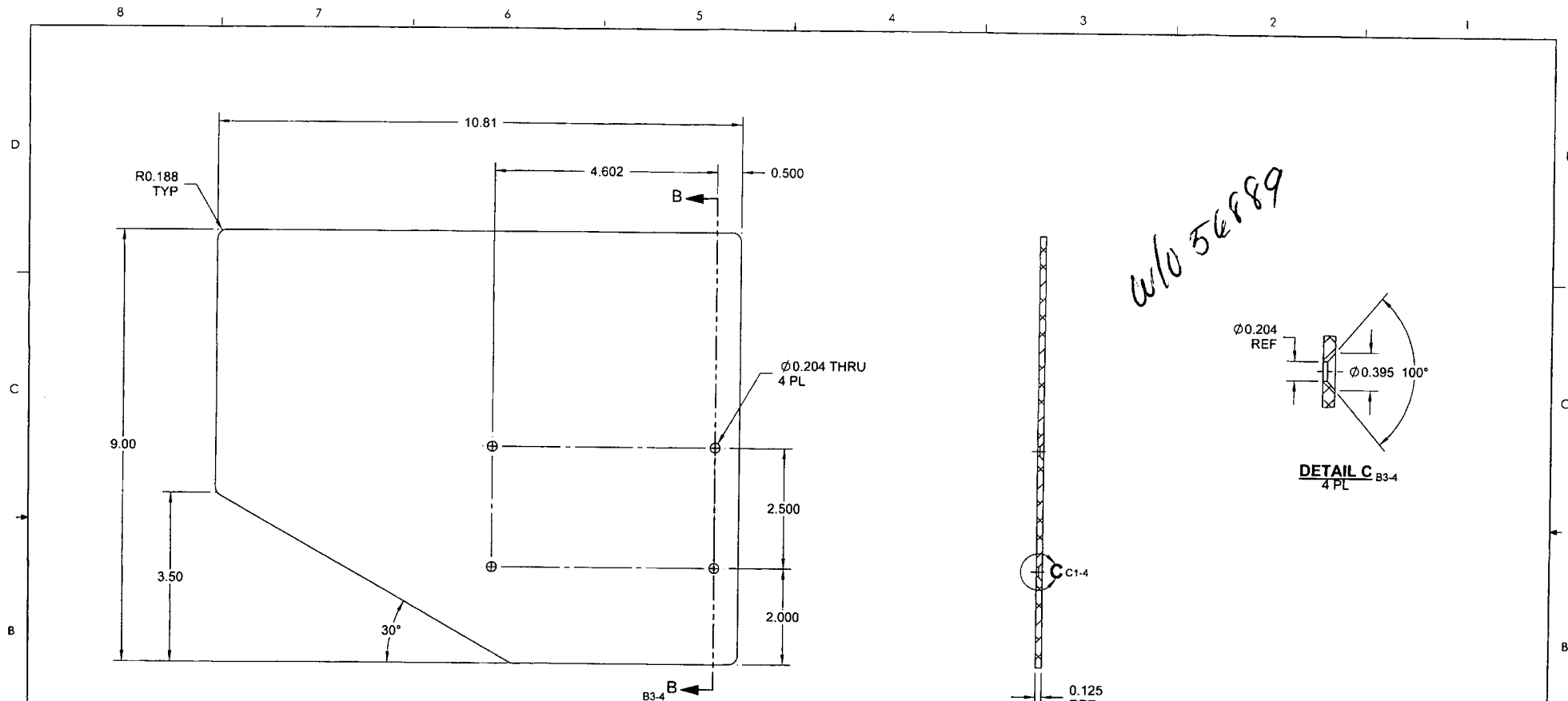
**D3694-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),  
PER PER AMS 5513 OR AMS 5524  
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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09/02/05

w/b 36889



**D3694-5 MOUNTING PLATE**

**SECTION B-B B5-4**

**RELEASED**  
6/2/05

**D3694-5 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027  
REF: DART SPEC. M6081T6S. 125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3694</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING PLATE ASSY</b>	NTS
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